Question: When using a WPS for a weld repair which is different than the WPS used to make the original girth weld which meets Appendix A, is there a maximum length and depth of repair weld beyond which the repair WPS must meet Appendix A?

Response: Appendix A does not address this issue.

However: From API 1104 twentieth edition

“This use of this appendix is restricted to the following conditions:
• Circumferential welds between pipes of equal nominal wall thickness.
• Nondestructive inspection performed for essentially all welds.
• No gross weld strength undermatching, see A.3.2.1.
• Maximum axial design stress no greater than the specified minimum yield strength (SMYS).
• Maximum axial design strain no greater than 0.5%.
• Welds in pump and compressor stations, repair welds, fittings and valves in the main line are excluded.”

Therefore: API 1104 specifically addresses the situation by stating that all repairs are excluded from being evaluated by Appendix A. “Not Addressed” has a different connotation than “excluded.”

Proposed modified/corrected response
Per Section A1, Appendix A may not be used to assess repair welds.